

14

Date: Tuesday, 3/11/2008 7:50:46 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 SKIDTUBE
Job Number : 37714
Estimate Number : 11650
P.O. Number :
This Issue : 3/11/2008 S.O. No. :
Prsht Rev. : NC Part Number : D058672012
First Issue : / / Type : LANDING GEAR Drawing Number : N/A
Previous Run : 37711 Drawing Revision : N/A
Material :
Due Date : 3/31/2008 Qty: 1 Um: Each
Written By : JO 8-3-11
Checked & Approved By :
Comment : Est Rev:G 02.06.27 Re-format; CHG002 (MPP 2251); ECN 258K
J
Est Rev:H 07-03-08 As per IIN D058-672 Rev C jlm

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photo Copy Blue files and Type Labels as per PPP D058-672-012 CHG003

08/04/15 08/03/25

2.0 37714A OH-58 SKIDTUBE ASSEMBLY



Comment: Sub-Component 1 D058-672-041 OH-58 SKIDTUBE ASSEMBLY

37714A SQ

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D29332 206 Saddle Right



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2933-2 Saddle 1537423

SQ

5.0 D29322 206 Saddle Right side



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2932-2 Saddle 37865X

8/4/10 SQ (14)

8/4/14 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D058672012

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Seq. #: Machine Or Operation: Description :

6.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B37369

SP

7.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B37867

SP

8.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN3-41A

Bolt

M106574

SP

9.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch =

16 D2652

Bushing

B37453

SP

10.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M107534

SP

11.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 MS21042L3

Nut (or -3)

M106883 (6x)
M106242 (2x)

8/4/10 SP (1x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

12.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-10A Bolt M10703

SP

13.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-12A Bolt M104885

SP

14.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD516 Washer M107008

SP

15.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-6A Bolt M105810

SP

16.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M106780

SP

17.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8/4/9

SP

(1x)

W/O:		WORK ORDER CHANGES					
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Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description:

12 MS21042L4 Nut (or -4)

18.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

10 D2712

Set Screw

B334628

SP

19.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2968-043

Tow Ring

B32503

SP

20.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

Batch:

5519

SP

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN970-4

Washer

M1072412

SP

22.0

MS210424

USE MS21042L4



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

USE MS21042L4

Batch:

M106825

SP

23.0

D058672043

GROUND HANDLING KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GROUND HANDLING KIT

BATCH:

B337841

8/4/9

SP

(14)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/15 *(K)*

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-672-012

Location: *PPP 37714*

PPP Rev: *Rev. C*

08/04/15 *(K)*

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15 *(K)*

Job Completion



mf 08-04-15

B37714A

W/O:		WORK ORDER CHANGES					
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012

14

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Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 0H-58 SKIDTUBE ASSEMBLY
Job Number : 37714A	
Estimate Number : 10475	
P.O. Number :	Part Number : D058672041
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2922 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : A1
Previous Run : 37711A	Material :
Written By : <u>JTD 8.3.11</u>	Due Date : 3/31/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:C 02.06.28 Re-format; ECN 258 KJ Est Rev:D 06.02.06 Added Dt8025 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D058-672-041 CHG 001

N/A

2.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	<i>32449</i>

SL 8-3-31

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube *SL 8-3-31*

2-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.
A/R Aluminum Rod *m106330/m106762*

BE 08/03/31

3-Cut aft end of D2620 bent tube as per dwg D2922

4-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia.

5-Drill holes for wearplates using DT 8487 Open to 0.297" dia.

6-Open holes for aft cap and tow ring as per Dwg D2922 .

SL 8-4-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 37714A

Part Number: D058672041

Job Number:



Seq. #: Machine Or Operation: Description:

8-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2922

9-Deburr and Blow out all chips form inside the tube

SL 8-4-1

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-04-01

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/08/04/01

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

K 8-4-2

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BB 08-04-02

8.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty/Part Number Description Batch

1 D2923

Web

037863

0 K 8-4-2

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

3-Deburr and Blow out all chips from inside the tube

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R

Sikaflex-291

Sikaflex expire date: 2-7-1

1105585

K 8-4-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 37714A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/03

11.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number

Description

Batch

1 D2794

Fwd Cap

B14588 BE 08/03/31

12.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

22 D2649

Crossbolt spacer

B37329 BE 08/04/03

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922. (Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

M106330 BE 08/04/03

3-Grind welds flush as per Dwg D2922

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

8-4-4

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/04/07

15.0

QC10

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-07/8 08/04/07

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Pressure wash M 107550

08-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 37714A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-07

(X1)

18.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

5 D2648-3 Wearpad 1333992

HL

19.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-15 Wearshoe 1334596

HL

20.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-21 Wearshoe 1333089

HL

21.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2924 Wearshoe 1335368

HL

22.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

50 MS27039-1-08 Screw M106589

HL

08-04-07

(X1)

W/O:		WORK ORDER CHANGES					
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Job Number: 37714A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description:

23.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
50	AN960JD10L	Washer	M104885

JP

24.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
50	ALS4-1032-130	Insert	M105854

or (see QSI 017)

JP

25.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2651-1	Plugs	B38273

X

JP

08-04-09 (X)

26.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2651-3	O-Rings	B36141

JP

27.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B37755

JP

08-04-07 (X)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

M106589

JP

29.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer

M104885

JP

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291

M105585

Sikaflex expire date: 08-07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291

M105585

Sikaflex expire date: 08-07

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

M107385

Batch: M107385

JP 08-04-08

31.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

32.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JP 08/04/09

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

37714

8/4/10

50

12

34.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-15

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DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY SCALE NTS	
A	99.10.14	NEW ISSUE	
A1	# CP 01.08.20	φ0.640 WAS φ0.625	

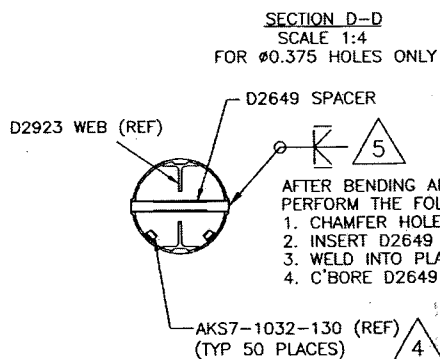
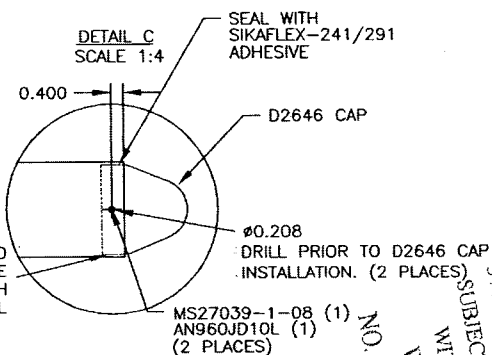
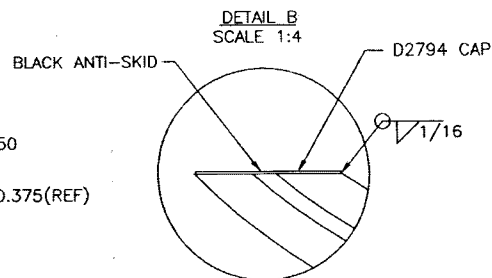
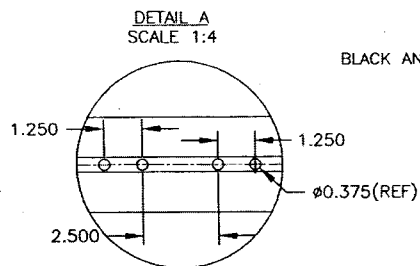
RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP.
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

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GENERAL NOTES:

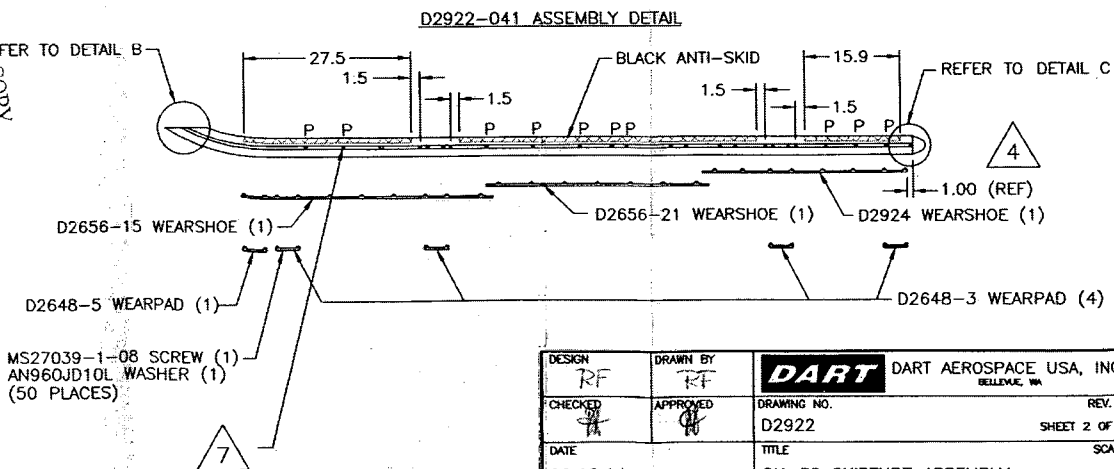
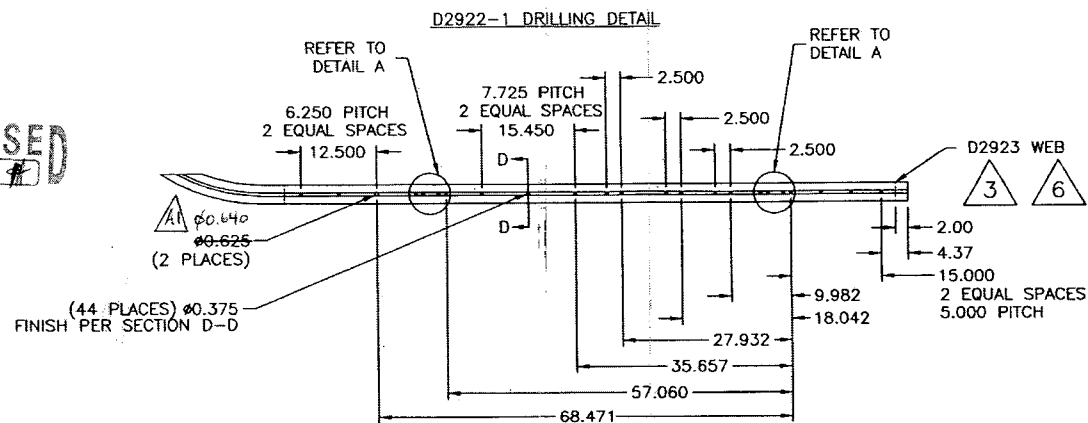
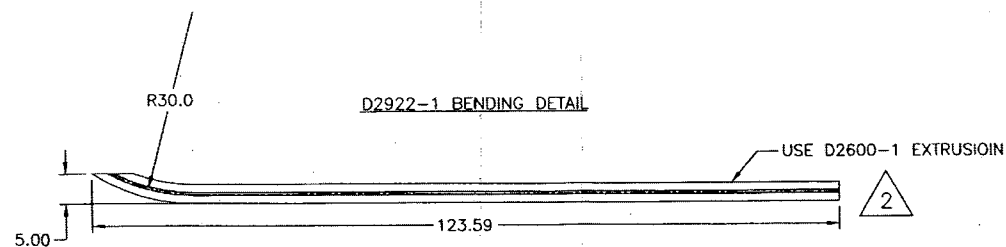
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).



- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER (22 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2649 SPACER TO 0.313 X 0.75 DEEP

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00.05.11

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DESIGN RF	DRAWN BY RF	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922
DATE 99.10.14	TITLE OH-58 SKIDTUBE ASSEMBLY	REV. A SHEET 2 OF 2 SCALE 1:20

NO. 146

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 37704A
Part number: D058 612 041
Description: OH-S8 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pct Dupal Date of Test Coupon 08-03-28

Welder Barclay Elliot Date of Test Coupon 08-03-28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld